

# Work Order ID 85600

**\*85600\***

Page 1

June-12-12 8:39:42 AM

Item ID: D4314-3

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Shim

Start Date: 12/06/2012 Start Qty: 24.00

**\*24\***

Cust Item ID:

Required Date: 26/06/2012 Req'd Qty: 24.00

**\*24\***

Customer:

Reference:

Approvals:

Process Plan: *MLJ*

Date: *12/06/12* Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4314

A

100

0.00

**\*100\***

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D4314

*6061 .188*

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

*24 0 Jun 12-6-19*

110

0.00

**\*110\***

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*24 0 Jun 12-6-19*

120

0.00

**\*120\***

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*507606/19*

*counts*  
*474*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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# Work Order ID 85600

**\*85600\***

Page 3

June-12-12 8:39:42 AM

Item ID: D4314-3

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Shim

Start Date: 12/06/2012 Start Qty: 24.00

**\*24\***

Cust Item ID:

Required Date: 26/06/2012 Req'd Qty: 24.00

**\*24\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170

QC3- Inspect Part Finish

0.00

**\*170\***

QC

Memo

0.00

Quality Control

*12/6/2012*

180

Identify as per dwg & Stock Location: 106

0.00

**\*180\***

Packaging

Memo

0.00

Packaging

*24*

*12/06/2012*

190

QC21- Final Inspection - Work Order Release

0.00

**\*190\***

QC

Memo

0.00

Quality Control

*12/10/2012*  
*MCJ 12/06/2012*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

# Picklist Print

June-12-12 8:39:46 AM

Page 1

Work Order ID: 85600

\*85600\*

Parent Item: D4314-3

\*D4314-3\*

Parent Item Name: Shim

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP REV:A NEW ISSUE 11-02-02 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.188		Purchased	No			100	sf	20.8700	0.0194	0.490105			

\*M6061T6S 188\*

6061-T6 .188 Sheet

\*\*

Jm 12-6-14

Location

Loc Qty

Loc Code

MAT021

20.87

116604

20.87

116604

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**NOTE:** Date & initial all entries





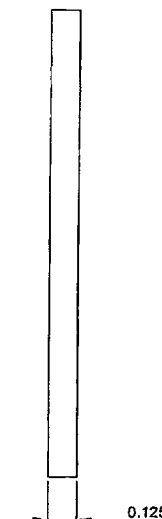
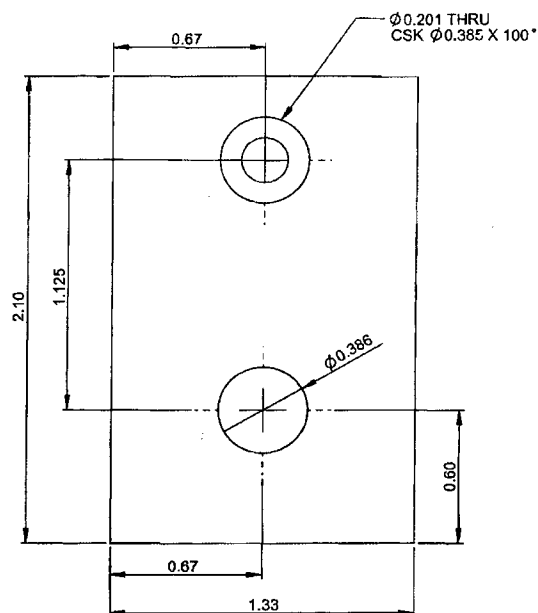
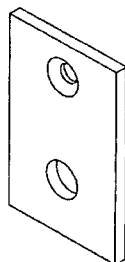
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



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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 85600 MLJ  
12/06/12

**D4314-1 SHIM**

RELEASED  
R 2011-02-13  
MB

**NOTES:**

- 1) MATERIAL: ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS-QQ-A-250/4  
OR AMS 4037 OR ASTM B209 (REF DART SPEC M2024T3S.125)  
OR  
ALUMINUM 6061-T6/T62 SHEET PER QQ-A-250/11 OR AMS-QQ-A-250/11  
AMS 4025 OR AMS 4027 OR ASTM B209 (REF DART SPEC M6061T6S.125)  
OR  
ALUMINUM 5052-H32 SHEET PER QQ-A-250/8 OR AMS-QQ-A-250/8  
AMS 4016 OR ASTM B209 (REF DART SPEC M5052H32S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

A	NEW ISSUE		SC	11.01.13
REV.	DESCRIPTION		BY	DATE
DESIGN	SC	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	SC			
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D4314	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.		SHIM	NTS	
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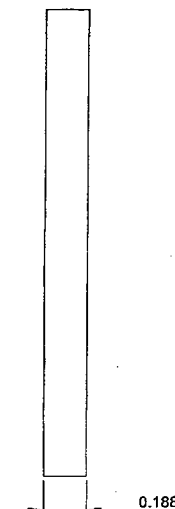
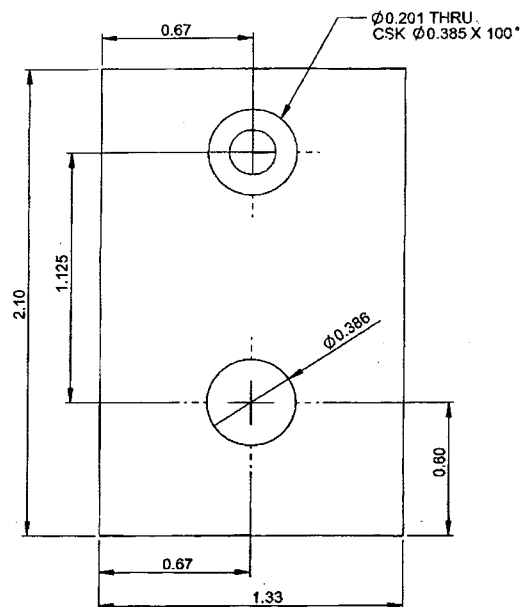
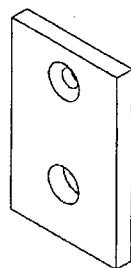
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**D4314-3 SHIM**

**RELEASED**  
2011-02-01  
*MP*

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- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.05 lbs

DESIGN	SC	<b>DART AEROSPACE LTD</b>	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>MP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>MP</i>	<b>D4314</b>	SHEET 2 OF 2
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	<b>SHIM</b>	NTS
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